

Date: Thursday, 4/26/2007 3:33:59 PM
User: Kim Johnston

Process Sheet

Customer	:	CU-DAR001 Dart Helicopters Services	Drawing Name	:	SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number	:	32078			
Estimate Number	:	10533			
P.O. Number	:	N/A	Part Number	:	D2573
This Issue	:	4/26/2007 S.O. No. : N/A	Drawing Number	:	D2573 REV E
Prsht Rev.	:	NC	Project Number	:	N/A
First Issue	:	N/A Type : MACHINED PARTS	Drawing Revision	:	E
Previous Run	:	31721	Material	:	N/A
Written By	:	<u>JLM 07.04.26</u>	Due Date	:	5/30/2007 Qty: 10 Um: Each
Checked & Approved By	:	<u>[Signature]</u>			
Comment	:	Est: I As Per RevE 06-01-27 JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2573

Ensure that grain is along 7.75" length

Batch No: _____

325 353 (710) Σ 07/05/30

20

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. B32018 Double check by: J.Y.

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per

Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

En fml 07/06/03

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 & D2574

Col/mk 07/06/03

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Ex 19ml 07/06/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: RD Date: 07/06/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/26/2007 3:33:59 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 32078

Part Number: D2573

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/06/04 (10)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FX

07/06/04 (10)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat - OLIVE DRAB GREEN

(Ref: 4.3.5.1) as per QSI 005 4.3

m/04476.

FX

07/06/04 (10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/06/05 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/06/05 (10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/05

Job Completion



07/06/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32078
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.749	1.749	1.749	1.749		
C	3.495	3.505		3.499	3.499	3.499	3.499		
D	1.745	1.755		1.749	1.749	1.749	1.749		
E	7.990	8.010		8.000	8.000	8.000	8.001		
F	0.490	0.510		0.497	0.505	0.502	0.504		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.501	0.502	0.502	0.503		
J	1.174	1.184		1.175	1.178	1.178	1.177		
K	0.558	0.578		0.565	0.570	0.571	0.570		
L	1.174	1.184		1.175	1.178	1.178	1.177		
M	1.365	1.375		1.368	1.369	1.369	1.368		
N	2.495	2.505		2.499	2.500	2.500	2.500		
O	4.119	4.129		4.123	4.121	4.121	4.120		
P	0.115	0.135		0.126	0.126	0.126	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.252	0.251	0.252		
S	0.115	0.135		0.127	0.130	0.124	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.240	0.244	0.246	0.241		
W	0.115	0.135		0.127	0.134	0.130	0.130		
X	0.308	0.313		0.310	0.311	0.311	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.360	0.360	0.362	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.633	0.633	0.633		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.255	0.253	0.254		
AE	1.500	1.520		1.510	1.509	1.512	1.511		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.251	0.253	0.249	0.250		
AI	2.000	2.020		2.000	2.000	2.001	2.000		
AJ	0.023	0.043		0.032	0.033	0.033	0.033		
Accept/Reject									

Measured by:	En/Am
Date:	07/06/01

Audited by:	SA
Date:	07.06.02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32078
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
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A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.749	1.748	1.748	1.745		
C	3.495	3.505		3.499	3.501	3.497	3.495		
D	1.745	1.755		1.745	1.748	1.748	1.748		
E	7.990	8.010		8.003	8.003	8.006	8.004		
F	0.490	0.510		0.500	0.499	0.500	.499		
G	0.257	0.262	DT8683	0.259	0.259	0.260	0.260		
H	0.375	0.380	DT8684	0.376	0.376	0.377	0.377		
I	0.490	0.510		0.503	0.503	0.500	.501		
J	1.174	1.184		1.178	1.179	1.178	1.175		
K	0.558	0.578		0.569	0.570	0.566	.564		
L	1.174	1.184		1.178	1.179	1.178	1.178		
M	1.365	1.375		1.369	1.369	1.368	1.369		
N	2.495	2.505		2.500	2.500	2.497	2.498		
O	4.119	4.129		4.121	4.122	4.121	4.121		
P	0.115	0.135		0.126	0.126	0.126	.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.252	0.251	.251		
S	0.115	0.135		0.126	0.122	0.122	.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.236	3.230	3.230		
V	0.230	0.250		0.241	0.246	0.237	.244		
W	0.115	0.135		0.130	0.129	0.126	.129		
X	0.308	0.313		0.310	0.311	0.311	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.360	0.360	0.360	0.360		
AA	0.470	0.530		0.500	0.506	0.500	0.500		
AB	0.615	0.635		0.628	0.626	0.627	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.253	0.253	0.243	.248		
AE	1.500	1.520		1.511	1.512	1.514	1.513		
AF	0.115	0.135		0.126	0.129	0.135	0.135		
AG	0.240	0.280		0.265	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.248	0.247	.246		
AI	2.000	2.020		2.000	2.002	2.003	2.003		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	<i>gmk / En</i>
Date:	<i>07/06/02</i>

Audited by:	<i>J.F.</i>
Date:	<i>07/06/04</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	32078
Description: Saddle, Aft Outboard		Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1	

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B	1.745	1.755		1.749	1.749				
C	3.495	3.505		3.501	3.499				
D	1.745	1.755		1.749	1.749				
E	7.990	8.010		8.005	8.002				
F	0.490	0.510		0.499	0.500				
G	0.257	0.262	DT8683	0.260	0.260				
H	0.375	0.380	DT8684	0.377	0.377				
I	0.490	0.510		0.502	0.502				
J	1.174	1.184		1.178	1.176				
K	0.558	0.578		0.565	0.567				
L	1.174	1.184		1.178	1.176				
M	1.365	1.375		1.369	1.365				
N	2.495	2.505		2.497	2.497				
O	4.119	4.129		4.122	4.120				
P	0.115	0.135		0.125	0.127				
Q	0.115	0.135		0.135	0.135				
R	0.240	0.260		0.251	0.251				
S	0.115	0.135		0.123	0.122				
T	0.178	0.198		0.188	0.188				
U	3.210	3.250		3.280	3.230				
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W	0.115	0.135		0.123	0.125				
X	0.308	0.313		0.311	0.311				
Y	0.760	0.765		0.765	0.765				
Z	0.352	0.372		0.360	0.360				
AA	0.470	0.530		0.500	0.500				
AB	0.615	0.635		0.626	0.626				
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AG	0.240	0.280		0.260	0.260				
AH	0.240	0.260		0.248	0.248				
AI	2.000	2.020		2.000	2.003				
AJ	0.023	0.043		0.033	0.033				
Accept/Reject									

Measured by:	En
Date:	07/06/04

Audited by:	J.F
Date:	07/06/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
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D	05.05.05	Added dimension AI	KJ/RF	
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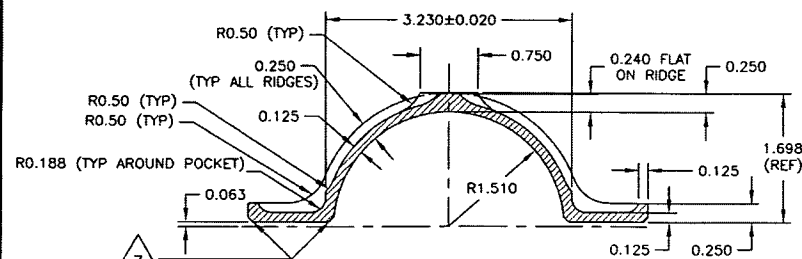
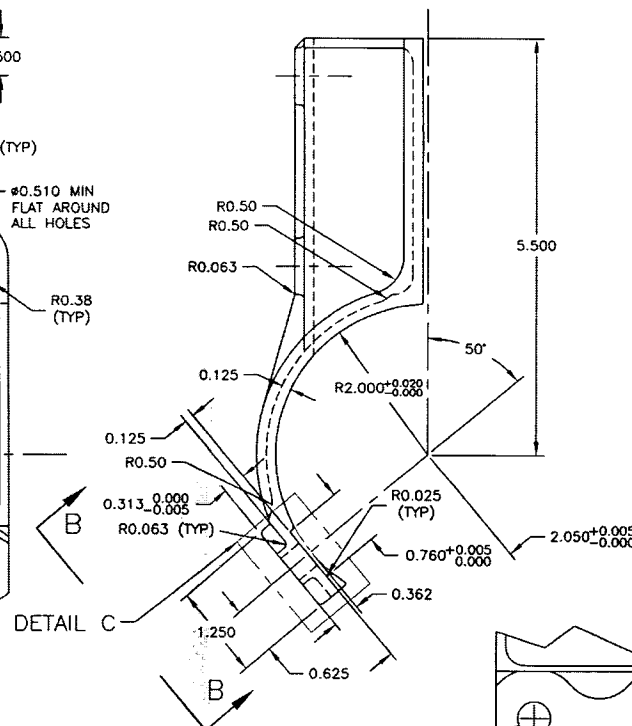
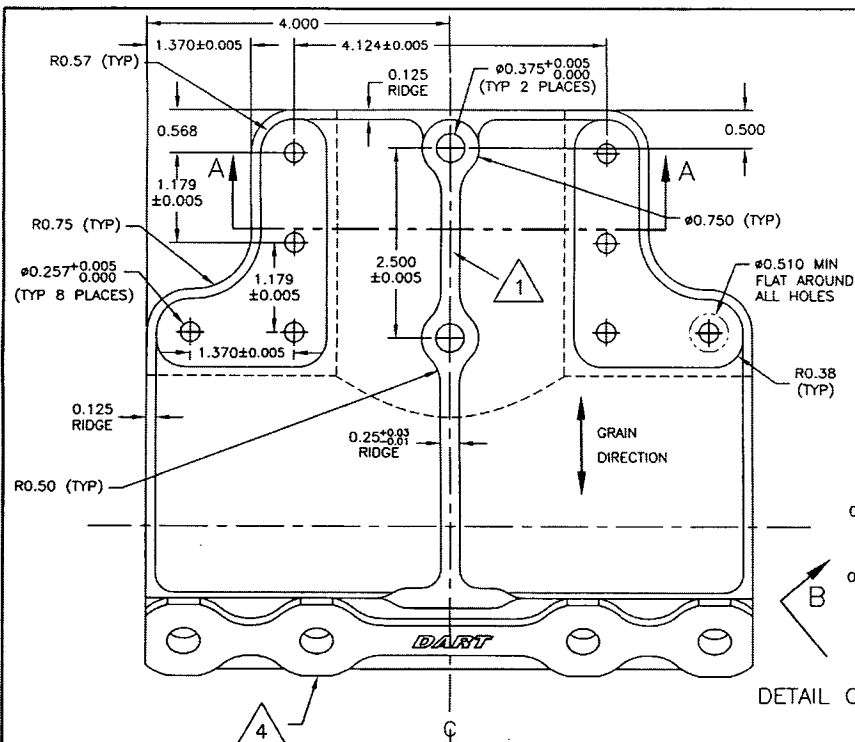
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
				1.1 1.2 1.3 1.4 1.5				

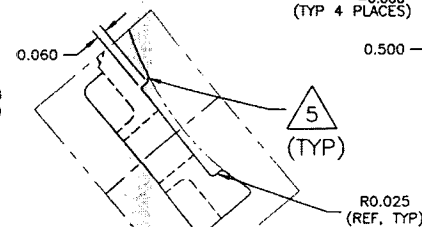
NOTE: Date & initial all entries

RELEASED

05.12.06



SECTION A-A

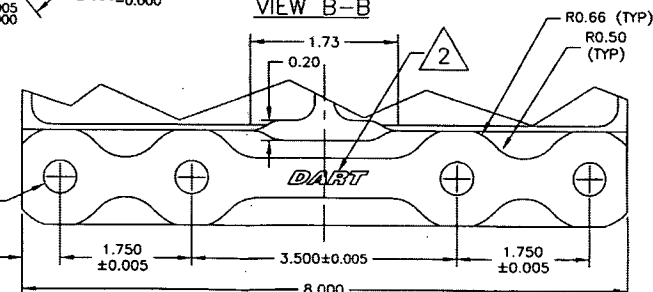
DETAIL C
SCALE 4:3

NOTES

MATERIAL: 7075-T7351 (Q0-A-250/12)
(REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

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DART AEROSPACE LTD.

DESIGN	DS	DRAWN BY	PH	DART	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO.	D2573
DATE	05.07.13	TITLE	OUTER AFT SADDLE	REV. E	SHEET 1 OF 1
				SCALE	2:3

NO. 32078
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries